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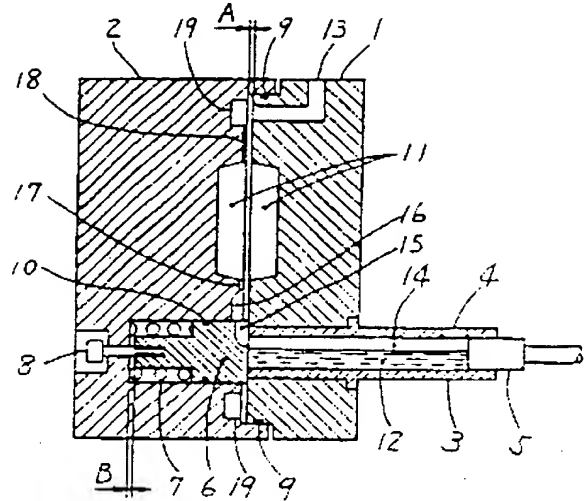
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TITLE : METHOD AND APPARATUS FOR DIE CASTING



ABSTRACT : PURPOSE: To efficiently produce the products having excellent quality by exhausting as sucking air in a metallic mold from a gap through the all face of matching face between a fixed mold and a shifting mold before finish of mold closing and then at the same time of the mold closing, filling up as injecting the molten metal.

CONSTITUTION: The mold closing is executed by a little distance for a gap (A) of the matching face of the molds. The molten metal 12 is poured into an injecting sleeve from the molten metal supplying hole 4, and at the same time, a plunger 5 is moved ahead to close the molten metal supplying hole 4. The air in the mold containing of a cavity 11 and in the inner part of the injecting sleeve by the vacuum suction device, connecting with an exhausting hole 13 of the fixed mold 1. At the same time of exhausting air, the mold closing is restored and at the same time of no gap, the molten metal 12 in the sleeve 3 is injected as filling up in the cavity 11. In this way, the products having high quality are efficiently produced.

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